

Work Order ID 126715

126715

Page 1

Friday, January 09, 2015 10:22:34 AM

Item ID: D350-589-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Side Door Latch Modification

Start Date: 11/24/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-11-24 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

INN-D350-589

E

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type label as per PPP D350-589-011 CHG002

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

110

QC4-100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

MLS 15-01-13
JAN 16 2015

4x

DAS
06
9-89

4

JAN 12 2015

DAS
06
9-89

CH750

DAS
28
9-89

4x

DAS
06
9-89

JAN 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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126715

Page 2

Friday, January 09, 2015 10:22:34 AM

Item ID: D350-589-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 11/24/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

60 22

4x

DAS

JAN 16 2015

MLJ 15-01-16

15-1-16

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Page 1

126715

D350-589-011

Start Date: 11/24/2014**Required Date:** 11/24/2014**Start Qty: 4.00**

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

[illegible]

DQA: _____ Date: _____



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Picklist Print

Friday, January 09, 2015 10:22:40 AM

Page 2

Work Order ID: 126715

126715

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 4.00

Required Qty: 4.00

D2586 Manufactured No

105 Each

16.0000

3 12

D2586
Door Latch

**

127402

DAS
06
9-89

DAS
28
9-89

DAS

Location

Loc Qty

Loc Code

FG

16

100607

1

114985

5

119746

4

83893

5

95760

1

D2587 Manufactured No

105 Each

36.0000

1 4

D2587
Door Plug

**

DAS
06
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008

36

114301

11

121824

25

D2589 Manufactured No

105 Each

22.0000

1 4

D2589
Keys, Key Chain

**

Location

Loc Qty

Loc Code

ST008

22

123246

22

JAN 12 2015

DAS
06
9-89

DAS
28
9-89

Friday, January 09, 2015 10:22:40 AM

Shop Packet Print

Page 2

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Friday, January 09, 2015 10:22:40 AM

Page 3

Work Order ID: 126715

126715

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5

Purchased

No

105

Each

2,674.000

6 24

**

DAS
06
9-89

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS

Location

Loc Qty

Loc Code

CCK004

2216

m128401

2216

GA

78

m128813

78

ST310

380

m128813

380

105

Each

551.0000

3 12

**

DAS
28
9-89

MS21042L3

Purchased

No

MS21042L3

Nut

DAS

Location

Loc Qty

Loc Code

FP001

489

M130922

489

ST305

59

M130799

59

ST307

3

123900

3

105

Each

197.0000

3 12

**

DAS
06
9-89

DAS
28
9-89

MS27039-1-15

Purchased

No

MS27039-1-15

Screw

DAS

Location

Loc Qty

Loc Code

GA

99

m127916

99

ST285

98

m127916

98

JAN 12 2015

DAS
06
9-89

DAS
28
9-89

Friday, January 09, 2015 10:22:40 AM

Shop Packet Print

Page 3

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Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

105

Each

1,822.000

3

12

***NAS1149D0363.I* /**

Washer

**

DAS
06
9-89

JAN 12 2015

DAS
45
9-89

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

154

m126319

154

GA

778

m128429

778

ST269

217

122378

165

m126319

52

DAS
28
9-89

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JAN 16 2015

DART AEROSPACE LTD.

DAS
45
G-17

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3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.